

# Technical Data

## Muki PVB 2-Pack



### Product description

Muki PVB 2-Pack is a vinyl phenolic resin modified quick drying primer with a very low content of free phenol.

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### Recommended use

To be used as a preconstruction primer on blast cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and production.

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### Film thickness and spreading rate

	Minimum	Maximum
Film thickness, dry (µm)	20	30
Film thickness, wet (µm)	155	230
Theoretical spreading rate (m <sup>2</sup> /l)	6,5	4,3

### Comments

Dry film thickness measured on a smooth test panel.

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### Physical properties

Colour	Grey, Red
Solids (vol %)*	13 ± 2
Flash point	-5°C ± 2 (Setaflash)
VOC	710 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Flat
Water resistance	Very good
Abrasion resistance	Good
Solvent resistance	Limited
Flexibility	Good

\*Measured according to ISO 3233:1998 (E)

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## Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

### Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:2007). Roughness: using abrasives suitable to achieve grade Fine to Medium S/G (30-85 µm, Ry5) (ISO 8503-2)

### Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

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## Condition during application

The temperature of the substrate should be minimum at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Relative humidity in the air should not exceed 85% prior to application. Recommended steel temperature: 30-40°C.

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## Application methods

<b>Spray</b>	Use airless spray or conventional spray
<b>Brush</b>	Recommended for touch-up purposes.

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## Application data

<b>Mixing ratio (volume)</b>	19.5 parts Comp. A (base) to be mixed thoroughly with 0,5 parts Comp. B (curing agent).
<b>Pot life (23°C)</b>	2-3 weeks
<b>Thinner/Cleaner</b>	Jotun Thinner No. 4/11 (No. 4 - Fast evaporation) - (No. 11 - Slow evaporation)
<b>Guiding data airless spray</b>	
<b>Pressure at nozzle</b>	5-8 MPa (50-80 kp/cm <sup>2</sup> 700-1120 psi).
<b>Nozzle tip</b>	0.38-0.58 mm (0.015-0.023).
<b>Spray angle</b>	40-95°
<b>Filter</b>	Check to ensure that filters are clean.

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## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate

<b>Substrate temperature</b>	<b>23°C</b>	<b>40°C</b>
<b>Surface dry</b>	2-3 min	20-40 sec
<b>Through dry</b>	4 min	1-2 min
<b>Dry to recoat, minimum</b>	4 h	4 h



